

Shop Oct 15

Dart Aerospace Ltd.

Date: Friday, 9/21/2007 1:19:06 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BRACKET ASSY
Job Number	34826			
Estimate Number	12522			
P.O. Number	N/A		Part Number	D35311
This Issue	9/21/2007	S.O. No. N/A	Drawing Number	UNDER REVIEW D3531
Prsht Rev.	NC		Project Number	N/A
First Issue	9/21/2007	Type	Drawing Revision	N/A A 10/07/09/24
Previous Run	33300		Material	N/A
Written By			Due Date	10/12/2007
Checked & Approved By			Qty:	5
Comment	Est Rev:A	New Issue 06-09.06 EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.3972 sf(s)/Unit Total : 1.9861 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M100742

RB 07-10-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: A

RB 07-10-3

Prog Rev: A

6

2-Deburr if necessary

RB 07-10-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RB 07-10-3

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



En 07/07/03 46

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Bend as per Dwg D3531

SB 07/10/10

PTO

⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/18/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/10	5	1 piece was scrapped out of tolerance at the set-up R.C channel error	<u>AB</u> <u>07/10/10</u>	Scrap & destroy	8S 07/10/10	En 07/10/10	<u>AB</u> 07/10/10	<u>CS</u> 07/10/10

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:19:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 34826

Part Number: D35311

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

5 07/10/09

(X5)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 07-10-10

(S)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-10-10

(S)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 07-10-10

(5)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/07/10/10

Job Completion



U 07-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

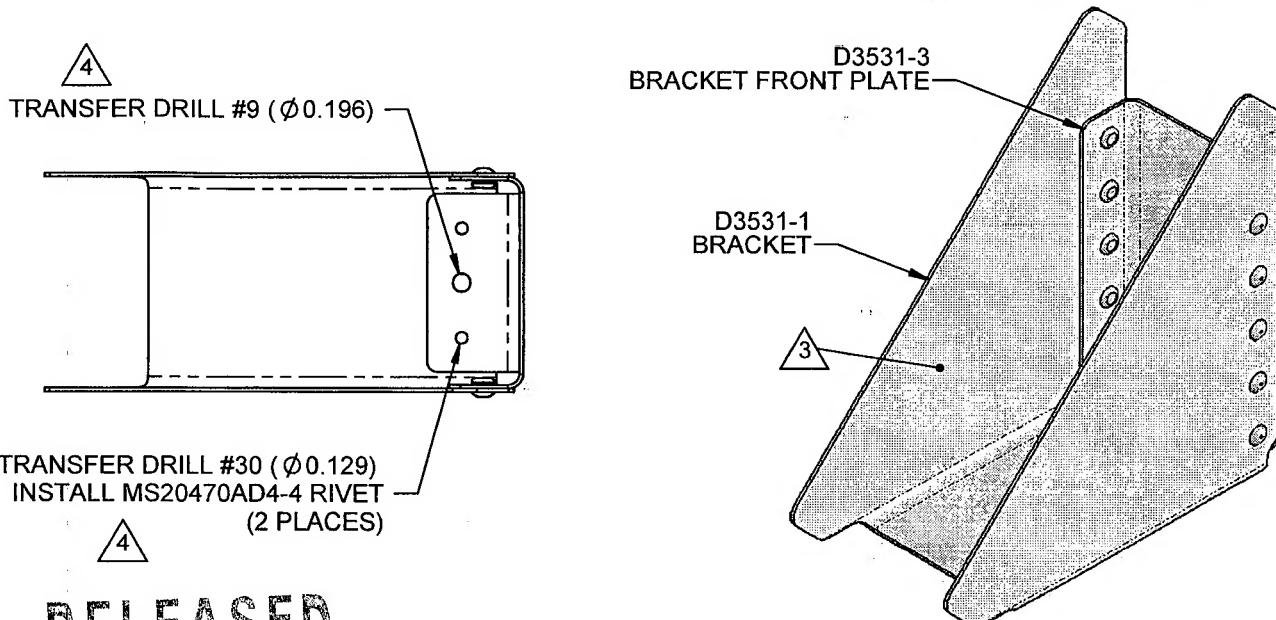
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

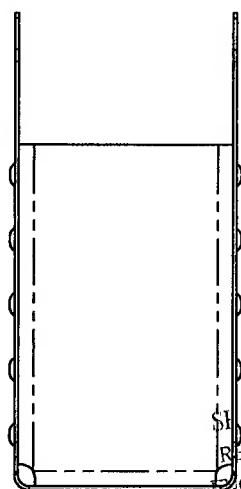
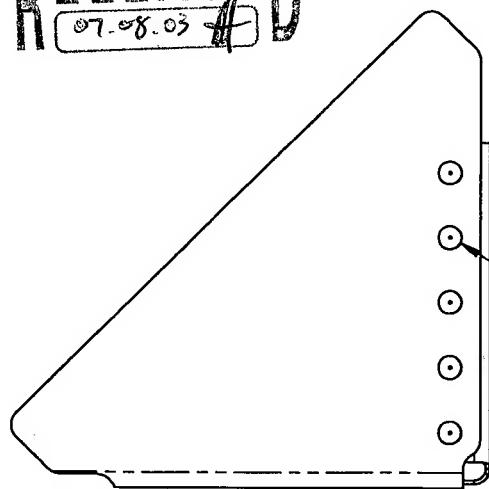
NOTE: Date & initial all entries



DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>JH</i>	DRAWING NO. D3531	REV. A	SHEET 1 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2	
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE		



RELEASED
07-08-03



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

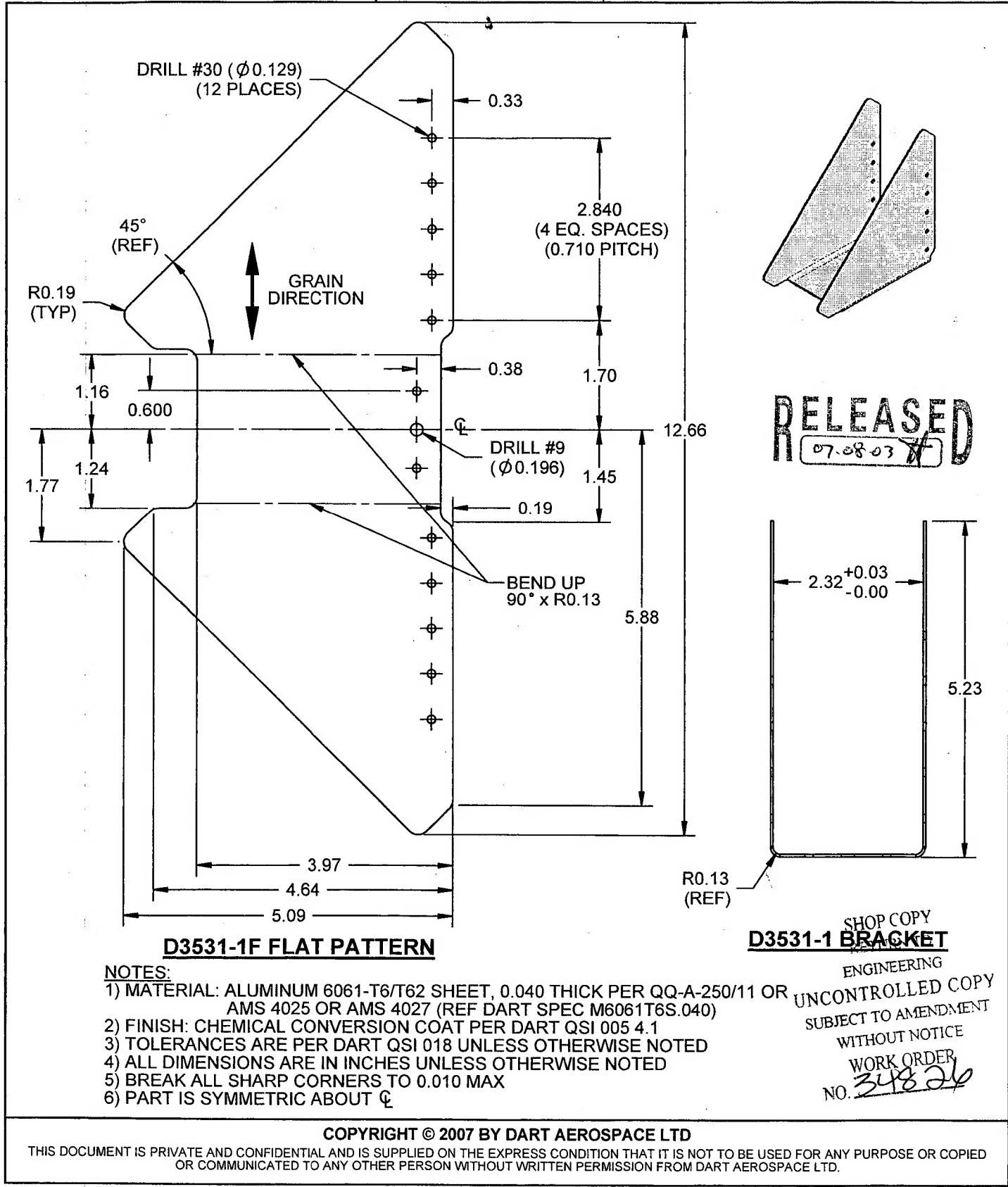
PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
3C830

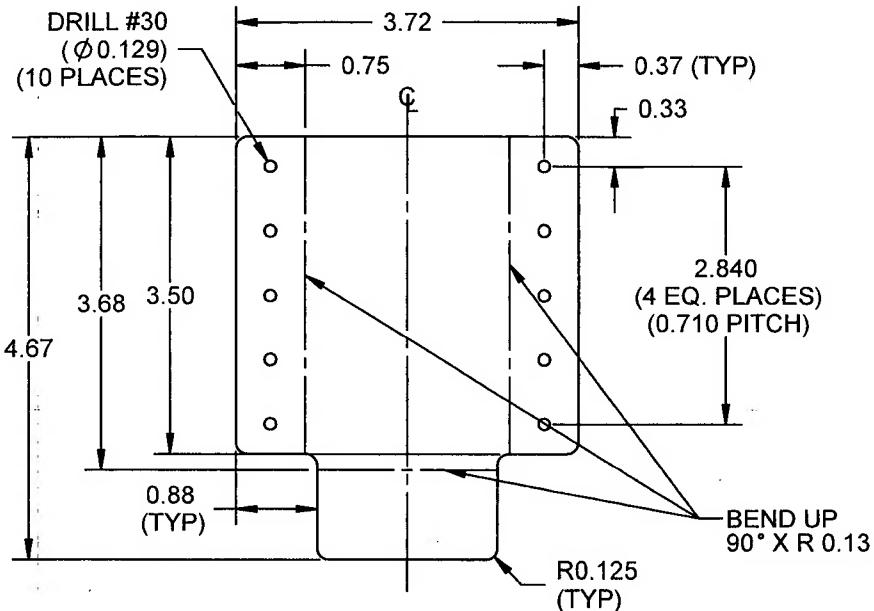


DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2

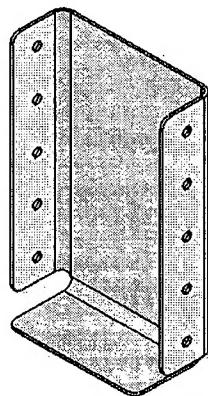




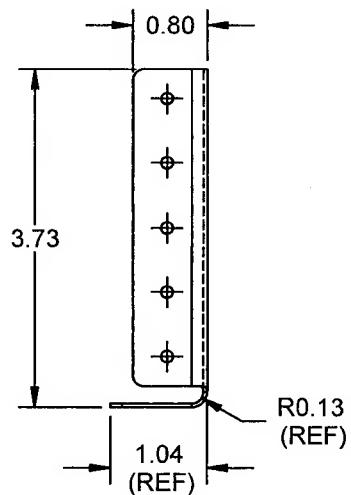
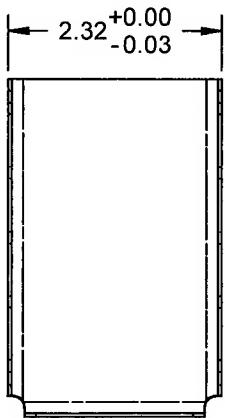
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED TH	DRAWING NO. D3531
DATE 07.06.19		REV. A SHEET 3 OF 3 TITLE SCALE 1:2 BRACKET ASSEMBLY



RELEASED
07.08.03



D3531-3F FLAT PATTERN



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \mathcal{C}

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34826

DART AEROSPACE LTD	Work Order:	34826
Description: BRACKET ASS'Y	Part Number:	D3531
Inspection Dwg: 3531	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>VB</u>	Audited by: <u>Cr</u>	Prototype Approval: <u>N/A</u>
Date: <u>07-10-3</u>	Date: <u>07/10/03</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

